



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5569-1

Job Sheet 197151



Part No: D5569-1

Job Qty: 4 pcs

7 JW

Part Name: Replacement Blade - Stainless Steel



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/2/19

Job Tracking No:

Due Date: 7/12/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D5569-1 REV:C IPP REV A 18.08.30 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Mori Seiki TL-40 - 1	4	7/12/19	7/12/19	1.00	16.00	Mori Seiki TL-40 - 1		DAS 66 2019/10/30
		pcs							
110	QC 2	4	7/12/19	7/12/19	0.00	0.00	QC 2 - 1		9-89
		pcs					QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		DAS 66 2019/10/30
							QC 2 - 64		9-89



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S228524



Part: D5569-1

Job No: 197151

Serial No/Batch: S228524

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/30/19

						QC 2 - 65	
						QC 2 - 5	
						QC 2 - 71	
						QC 2 - 73	
						QC 2 - 69	
120 HAAS 5 Axis - B4B	4 pcs	7/12/19	0.75	8.00	4	HAAS - 5 - B4B	mmL 20/01/08
130 QC 2	4 pcs	7/12/19	0.00	0.00		QC 2 - 1	
						QC 2 - 12	
						QC 2 - 14	
						QC 2 - 17	
						QC 2 - 19	
						QC 2 - 2	
						QC 2 - 20	
						QC 2 - 22	
						QC 2 - 23	
						QC 2 - 25	
						QC 2 - 32	
						QC 2 - 33	
						QC 2 - 35	
						QC 2 - 39	
						QC 2 - 4	
						QC 2 - 40	
						QC 2 - 44	
						QC 2 - 45	
						QC 2 - 48	
						QC 2 - 49	mmL 20/01/08
						QC 2 - 50	
						QC 2 - 51	
						QC 2 - 52	
						QC 2 - 57	
						QC 2 - 62	
						QC 2 - 63	
						QC 2 - 8	
						QC 2 - 66	
						QC 2 - 64	
						QC 2 - 65	
						QC 2 - 5	
						QC 2 - 71	
						QC 2 - 73	
						QC 2 - 69	
140 QC 8	4 pcs	7/12/19	0.00	0.00		QC 8 - 12	
						QC 8 - 14	mmL 20/01/10
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	
						QC 8 - 58	
						QC 8 - 8	
						QC 8 - 9	
						QC 8 - 68	

						QC 8 - 67	
						QC 8 - 1 (A)	
						QC 8 - 47	
						QC 8 - 40	
						QC 8 - 52	
						QC 8 - 23	
						QC 8 - 57	
180 Powdercoat - 1 White GI(A)- B4B	4 pcs	7/12/19	0.00	0.14		Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	BK 20-01-10.
						Powdercoat - 4 - B4B	
190 QC 3	4 pcs	7/12/19	0.00	0.00		QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	DAS
						QC 3 - 43	81
						QC 3 - 24	9-89
						QC 3 - 61	
						QC 3 - 81	JAN 10 2020
200 Packaging 3-1 - Stock - B4B	4 pcs	7/12/19	0.00	0.00		Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	DAS
						Packaging 3 - 6 - B4B	28
						Packaging 3 - 7 - B4B	9-89
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	

Plex 7/2/19 9:19 AM Dart.lajeunesse.marie

				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 QC 21 - SA	4 pcs	7/12/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	8-88
Part Op 100 - Mori Seiki TL-40 (Mori Seiki CNC Lathe Large) 1-Cut blanks at 22.800" 2-Turn as per dwg. and folio Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - HAAS 5 Axis (HAAS CNC vertical machine #5) 1-Machine as per Folio FC306 and Dwg. D5569-1 130 - (QC2- Inspect parts off machine FAI/FAIB) 140 - (QC8- Inspect parts - second check) <i>M235590</i> 180 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: <i>1:10</i> CUT: <i>1:00</i> FINISH: <i>2:10</i> 190 - (QC3- Inspect Part Finish) 200 - (Identify as per dwg & Stock Location: _____) LOCATION : FP001 210 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D6020-160	Crosstube Material	.5720 pcs (.143 ea)	100-Mori Seiki TL-40 - 1	<i>F141822</i>	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Mori Seiki TL-40 - 1	D6020-160	1	48	0	
Part Specifications					
Specifications could not be found.					

DART AEROSPACE LTD		Work Order:	197157
Description: Replacement Blade		Part Number:	D5569-1TRN
Inspection Dwg: D5569	Rev: C	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.240	+0.01/-0.000	3.238	✓		CNC-05	
		3.242	✓		CNC-05	
2.937	+0.01/-0.000	2.940	✓		CNC-08	
		2.944	✓		CNC-08	
20.10	+/-0.030	20.090	✓		Tape	
Ø5.516	+0.08 -0.001	5.516	///		VERAL-02	
1.10	±0.03	1.117	///		"	
4.10	±0.03	4.115	///		"	
15.60	±0.03	15.616	///			
17.60	±0.03	17.616	///			
Ø2.257	+0.006 -0.001	2.257	///		VERAL	
2.43	±0.03	2.425	///		"	
6.14	±0.03	6.147	///		HL	
5.198	±0.01	5.208	///		HL	
4.48	±0.03	4.485	///			
R1.0	±0.1	R1.0	///			
R2.5	±0.03	R2.5	///			
551	±0.01	554				

Measured by: JH/anne	Checked by: JH	QC Inspector:
Date: 20-1-06	Date: 20/01/10	Date:

Engineering Approval: (If necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐ Cross tube ☐ ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐ Engineering ☐ ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐		MRB (QS1042) ☐ ☐ ☐ ☐ ☐	
Date : _____		Sequence #: _____		QTY Affected : _____			
Description Work Order Deviation		Disposition		Completed By			
Root Cause Operator ☐ ☐ ☐ ☐ ☐ Manufacturing Process ☐ ☐ ☐ ☐ ☐ Equip/Tooling ☐ ☐ ☐ ☐ ☐ Handling/Preservation ☐ ☐ ☐ ☐ ☐ Material ☐ ☐ ☐ ☐ ☐ Product Improvement ☐ ☐ ☐ ☐ ☐ Process Improvement ☐ ☐ ☐ ☐ ☐ Human Factors ☐ ☐ ☐ ☐ ☐		FAULT CATEGORY Contamination ☐ ☐ ☐ ☐ ☐ Misaligned/off center ☐ ☐ ☐ ☐ ☐ BOM/Route ☐ ☐ ☐ ☐ ☐ Broken/Damage/Defect ☐ ☐ ☐ ☐ ☐ Incomplete/Unclear Instructions ☐ ☐ ☐ ☐ ☐ Drill Holes ☐ ☐ ☐ ☐ ☐ Fit/Function ☐ ☐ ☐ ☐ ☐		Power Loss/Surge ☐ ☐ ☐ ☐ ☐ Folio/Program ☐ ☐ ☐ ☐ ☐ Grain Direction ☐ ☐ ☐ ☐ ☐ Weld ☐ ☐ ☐ ☐ ☐ Wrong Stock Pulled ☐ ☐ ☐ ☐ ☐ Out of Sequence ☐ ☐ ☐ ☐ ☐ Off-set/Set-up ☐ ☐ ☐ ☐ ☐			
Other/Details: _____		Positioned Wrong ☐ ☐ ☐ ☐ ☐ Outside Tolerance ☐ ☐ ☐ ☐ ☐ Drawing ☐ ☐ ☐ ☐ ☐ Finish ☐ ☐ ☐ ☐ ☐ Part Lost/Missing ☐ ☐ ☐ ☐ ☐ Misread ☐ ☐ ☐ ☐ ☐		Lead hand / Supervisor QC / QA Coordinator			